

Work Order ID 86192

June-22-12 1:55:16 PM

86192

Page 1

Item ID: D3719-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 22/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 22/06/22 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3719	Rev A
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100	FLOW WATER JET	0.00
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100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3719 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

304 .063

6 0 Jun 12-7-4

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	-----------------------------------------	------

110

QC

Memo

0.00

Quality Control

6 0 Jun 12-7-4

120	QC8- Inspect parts - second check	0.00
-----	-----------------------------------	------

120

QC

Memo

0.00

Quality Control

5/2/2012

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1-Weld D3009-3 cups as per dwg D37192-Weld hard facing as per Dwg
D3719 A/R 2059B Hard Coat rod Batch: 11/02279

140

140

QC

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

Quality Control

150

150

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

SMB
12-8-16

DAS
16
9-89

12/06/17

DAS
18
9-89

12-08-16

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N9000040100

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Item Name: Wearplate

Stop ***NS2***

Start Date: 22/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
160									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 9:15	0.00							
	FINISH TIME: 9:45								
	OVEN TEMPERATURE:								
170	QC3- Inspect Part Finish	0.00							
170									
QC									
Quality Control	Memo								
180	Identify as per dwg & Stock Location: 500	0.00							
180									
Packaging									
Packaging	Memo								

6X4

M/L 12/08/20

6 6 M/L 12-8-20

Ad

6x

8 12/08/20

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Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

6

6

Customer:

Reference:

Approvals:

Process Plan:

Date:**Tooling:**

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

Accept Qty

Reject
QtyReject
Number

**Insp.
Stamp**

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 12/08/21
MLJ 12/08/20

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Picklist Print

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Page 1

Work Order ID: 86192

86192

Parent Item: D3719-041

D3719-041

Parent Item Name: Wearplate

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev :A New Issue 07-12-19 EC verified by DD
IPP Rev:B 08-09-25 add QC5 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3009-3		Manufactured	No			100	Each	82.0000	4	24			

D3009-3

Cup

**

12-8-15

85503 x11

Location

Loc Qty

Loc Code

WA

32

79078

30

80095

2

WA030

50

83174

50

M304S16GA

Purchased

No

130

sf

1.5746

0.565

3.568421

**

Im 12-74

M304S16GA

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

1.574633

121889

1.574633

122245

122245

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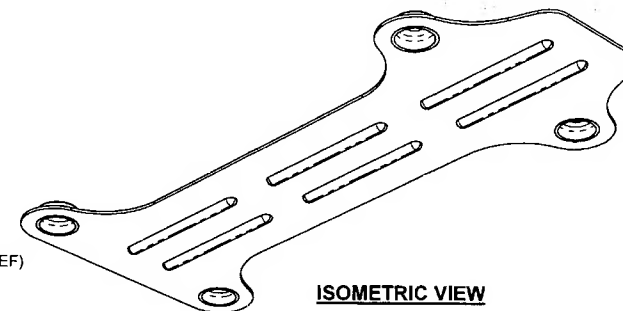
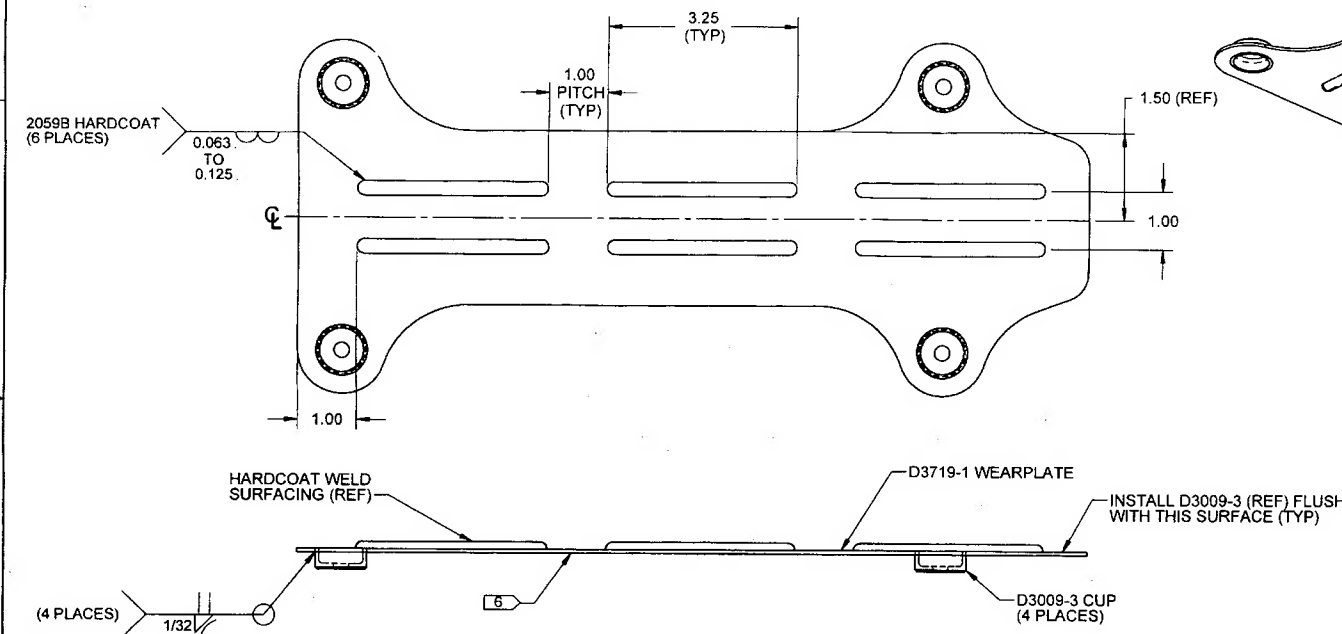
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PARTS LIST FOR D3719-041 WEARPLATE:		
QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 86192 MLJ
12/06/22

RELEASED
05-01-07 JML

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.11 lbs
 - 8) PART IS SYMMETRIC ABOUT CENTERLINE
 - 9) WELD PER DART QSI 004

A NEW ISSUE		CP	07.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.12		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3719	REV. A
TITLE WEARPLATE	SHEET 1 OF 2
	SCALE 1:2

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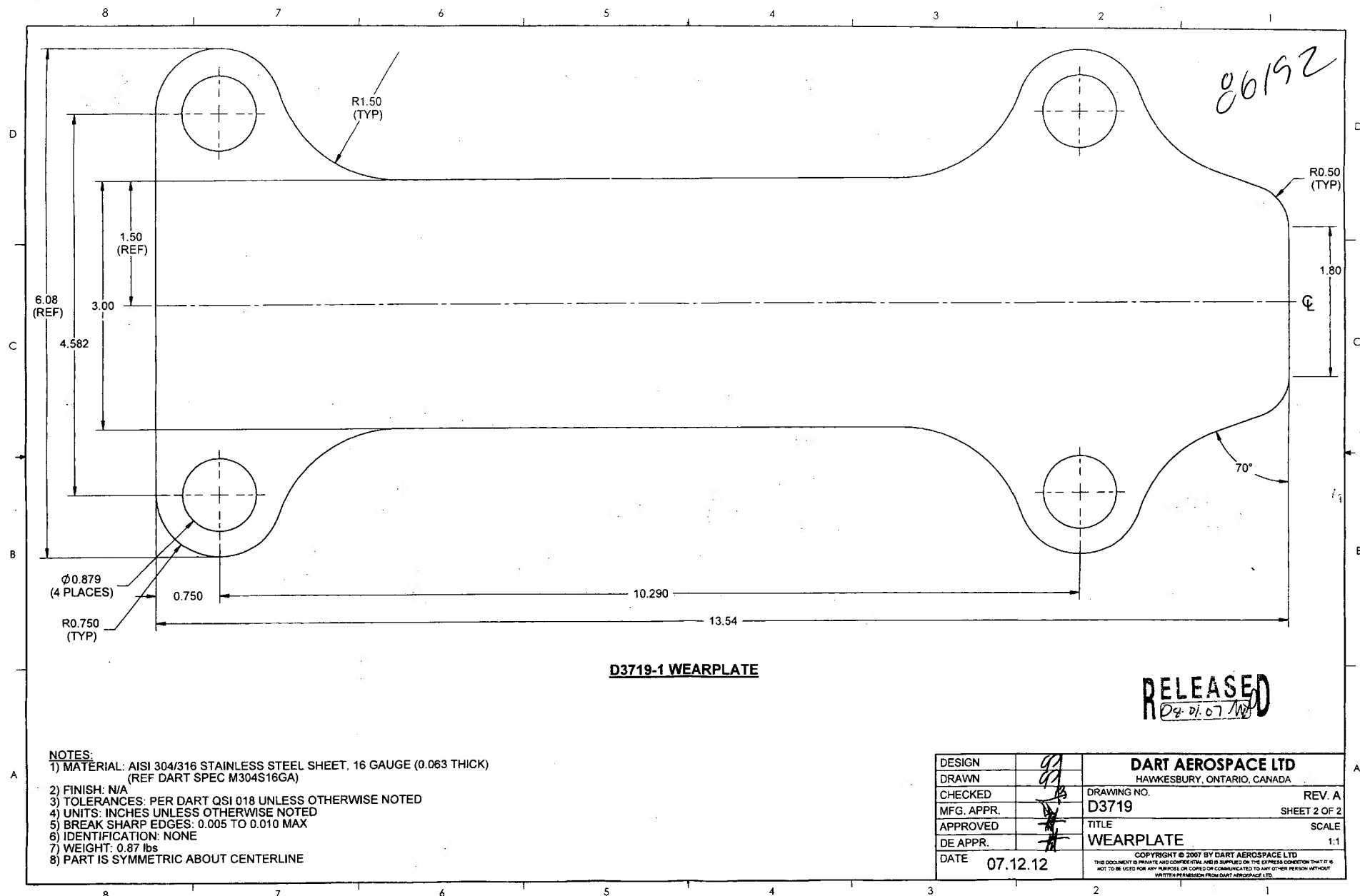
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